

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐		Temperature/Cure ☐	☐ Power Loss/Surge	☐ Positioned Wrong	
Design ☐	☐ Operator	Bending ☐		Set-up ☐	☐ Folio/Program	☐ Outside Dimensions	
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐		BOM/Route ☐	☐ Grain	☐ Over/Under tolerance	
Equip/Tooling ☐	☐ Supplier	Cracks ☐		Broken/Damage/Defect ☐	☐ Weld	☐ Part Incorrect	
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	☐ Wrong Stock Pulled	☐ Part Lost/Missing	
Material ☐	☐ Use for Testing	Cuffs ☐		Contamination ☐	☐ Out of Sequence	☐ Part Moved	
Internal Transport ☐	☐ Poor Information	Crushing ☐		Countersink ☐	☐ Off-set	☐ Drawing	
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐		Cut Too Short ☐	☐ Mislabeled	☐ Finish	
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	☐ Fit/Function	☐ Misread	
Substation ☐	☐ Process Improvement	Marks/Chatter ☐		Drill Holes ☐	☐ Misaligned/off center	☐ Turning Sequence	
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Work Order ID 146205

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146205

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Item ID: D3780-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Armrest Assembly
Start Date: 5/20/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/10/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89
AUG 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
				OTHER : ☐			

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Work Order ID: 146205

146205

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 5/20/2016

Required Date: 6/10/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3696-041 *D3696-041* Arm Assembly		Manufactured	No			100	Each	8.0000	1	2			PC
				<u>Location</u>				<u>Loc Qty</u>					
				ST457				8					
				143631				8		2			
D3781-041 *D3781-041* Lateral Cushion Assembly		Manufactured	No			100	Each	10.0000	1	2			PC
				<u>Location</u>				<u>Loc Qty</u>					
				ST458				10					
				143634				10		2			
D3781-043 *D3781-043* Armrest Cushion Assembly		Manufactured	No			100	Each	4.0000	1	2			PC
				<u>Location</u>				<u>Loc Qty</u>					
				ST458				4					
				143653				4		2			
D3785-3 *D3785-3* Bracket		Manufactured	No			100	Each	4.0000	1	2			PC
				<u>Location</u>				<u>Loc Qty</u>					
				ST458				4					
				56903				4		2			

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Work Order ID: 146205

146205

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 5/20/2016

Required Date: 6/10/2016

Start Qty: 2.00

Required Qty: 2.00

D3977-1

Manufactured No

100

Each

2.0000

1

2

D3977-1

Bolt

**

PC

Location

Loc Qty

Loc Code

ST067

2

139539

2

D3978-1

Manufactured No

100

Each

3.0000

1

2

D3978-1

Nut

**

PC

Location

Loc Qty

Loc Code

ST067

3

139521

3

D3979-1

Manufactured No

100

Each

20.0000

1

2

D3979-1

Washer

**

PC

Location

Loc Qty

Loc Code

ST067

20

55183

20

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Work Order ID: 146205

146205

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 5/20/2016

Required Date: 6/10/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

100

Each

1,340.000

2

NAS1149D0332.J******

Washer

LocationLoc QtyLoc Code

CA

6

m129682

6

FP001

11

m133988

11

GA

50

m132677

50

ST260a

600

m134738

600

ST264

673

m134502

673

AN970-6

Purchased

No

100

Each

33.0000

2

AN970-6******

WASHER

LocationLoc QtyLoc Code

ST321

33

M127532

13

M134063

20

④
x m1350416 PK

PK

4

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Work Order ID: 146205

146205

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 5/20/2016

Required Date: 6/10/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

100

Each

1,569.000

2

MS21042L3

Nut

**

4 m135056 PC

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

631

m133790

3

m134360

628

ST303

838

m134039

12

m134360

226

m134634

600

MS24665-302

Purchased

No

100

Each

67.0000

1

MS24665-302

Cotter Pin

**

2

PC

Location

Loc Qty

Loc Code

GA

17

120521

17

ST288

50

m134738

50

MS24693-C272

Purchased

No

100

Each

1,050.000

2

MS24693-C272

Screw

**

4

PC

Location

Loc Qty

Loc Code

OVER010

986

17137

467

17831

519

ST287

64

9370

64

4

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Work Order ID: 146205

146205

Parent Item: D3780-041

D3780-041

Parent Item Name: Armrest Assembly

Start Date: 5/20/2016

Required Date: 6/10/2016

Start Qty: 2.00

Required Qty: 2.00

MS24693-C277

Purchased

No

100

Each

80.0000

2

4

MS24693-C277

PC

Screw

Location

Loc Qty

Loc Code

ST287

80

m128060

80

NAS1149D0663J

Purchased

No

100

Each

866.0000

1

NAS1149D0663.J

4
2
Xn135 135 PC

Washer

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST263

588

M133134

89

M133769

12

M133812

6

M134634

481

ST269

51

M126334

51

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8

7

6

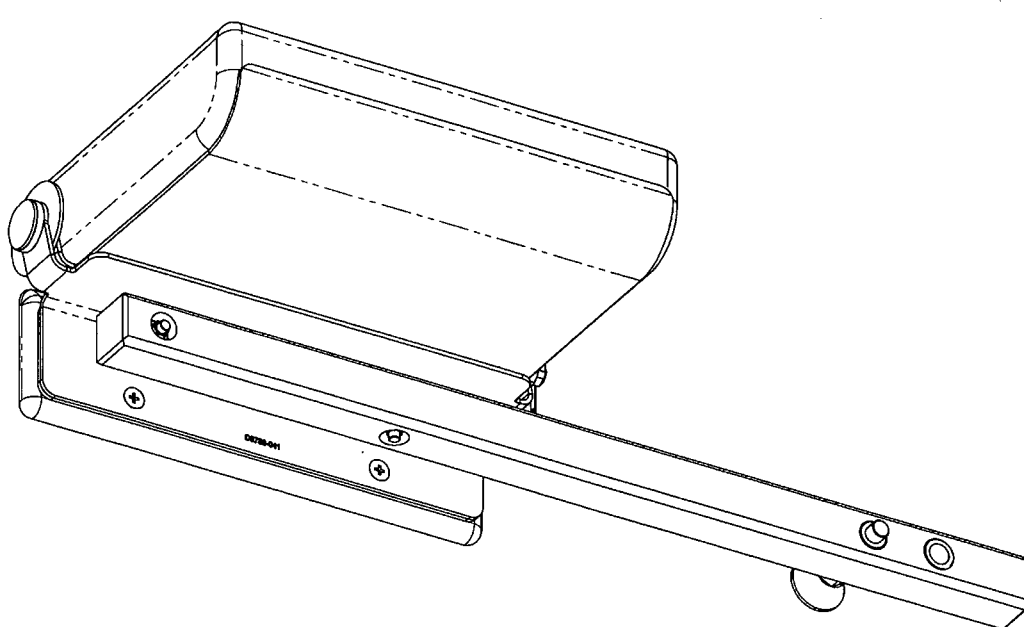
5

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2

1



D3780-041 ARMREST ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

20160511

SH

146205

RELEASED
09/07/21/14

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3780 TITLE ARMREST ASSEMBLY REV. D SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

7

6

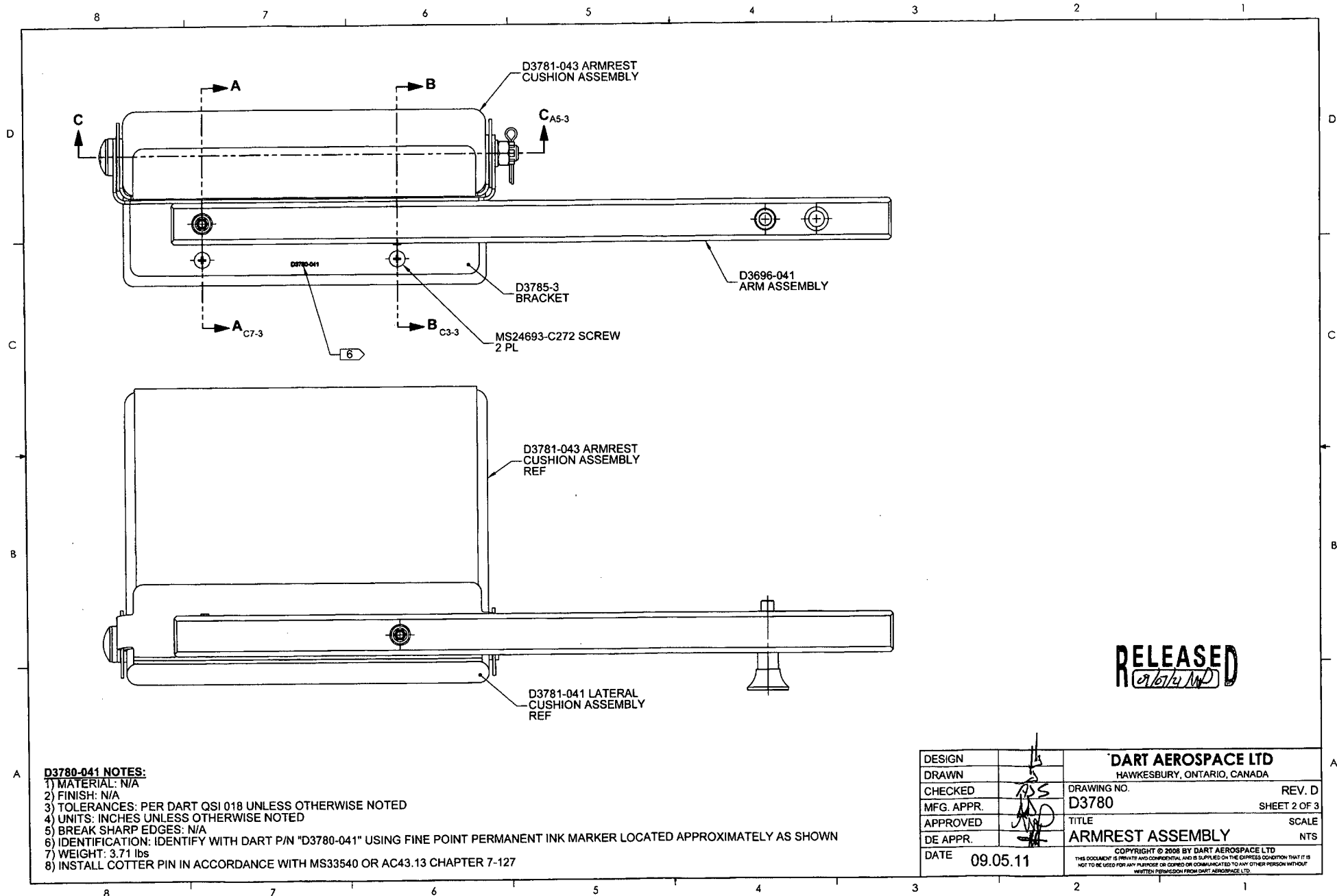
5

4

3

2

1



D3780-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 3.71 lbs
- 8) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540 OR AC43.13 CHAPTER 7-127

RELEASED
09/07/11 MD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

